

Work Order ID 108292

108292

Page 1

October-11-13 10:36:34 AM

Item ID: D4093-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 10/11/13 Start Qty: 10.00

10
10 #12#

Cust Item ID:

Required Date: 10/15/13 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: *J*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4093

D

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: *B*

PROG REV: *B*

HOLES WILL BE MADE ON MILLING

****DEBURR****

0.00

12

0

Ac
13.10.15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

12

0

Ac
13.10.15

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[illegible]

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10

Cust Item ID:

Required Date: 10/15/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

DAS

27

9-89

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 5T270 0.00***170***

Packaging

Memo

0.00

Packaging

12x	DAS	13-11-11
	28	
	9-89	

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Item ID: D4093-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Bracket

Start Date: 10/11/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/15/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

*DM 13/11/14**MF 13-11-11*

Picklist Print

October-11-13 10:36:34 AM

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Work Order ID: 108292

Parent Item: D4093-1

Parent Item Name: Bracket

Start Date: 10/11/13

Required Date: 10/15/13

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER REV C
11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.750X06.000

Purchased

No

f

32.0100

7

Aw 13.10.15

6061T6 BAR .750 X 6.00

Location

Loc Qty

Loc Code

MAT005

32.01

120866

30.78

121380

1.23

4.23

8.4

JP
12/10/30

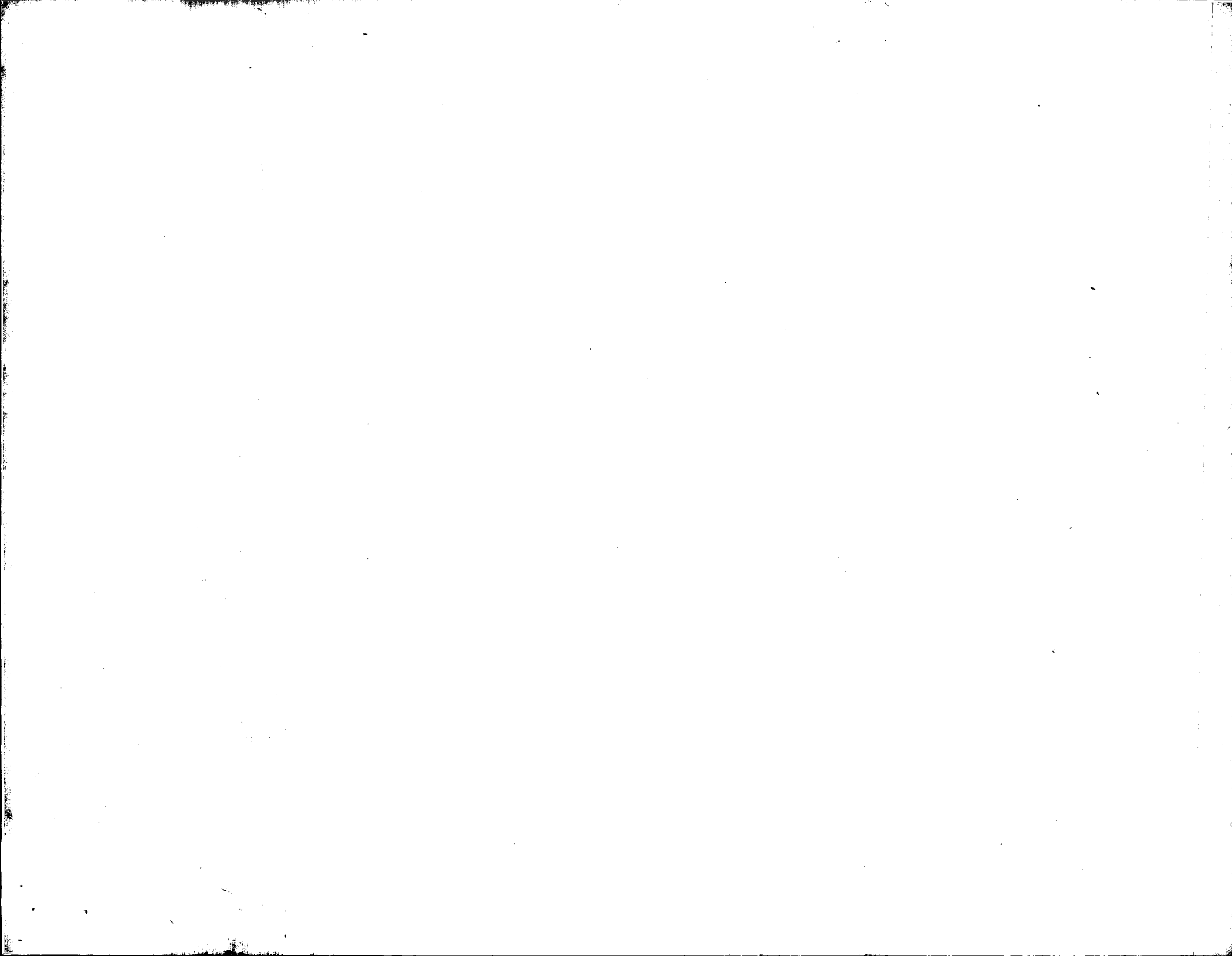
13.10.15

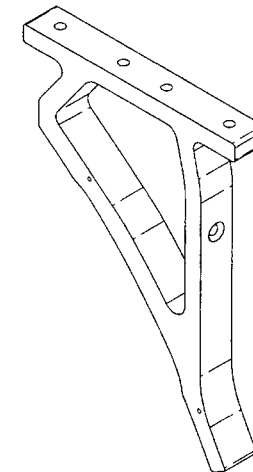
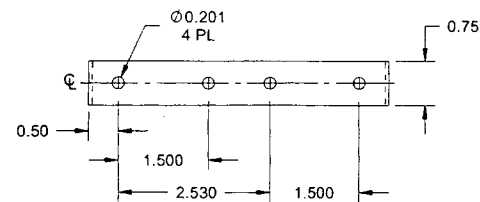
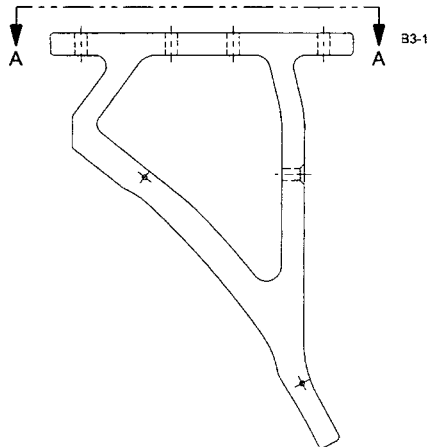
13.10.15

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13.10.15

13.10.15





SECTION VIEW A-A D6-1

RELEASED
2012-10-31

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs

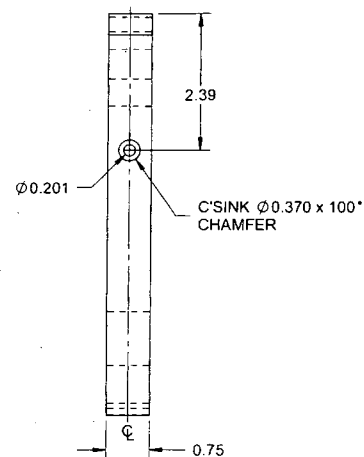
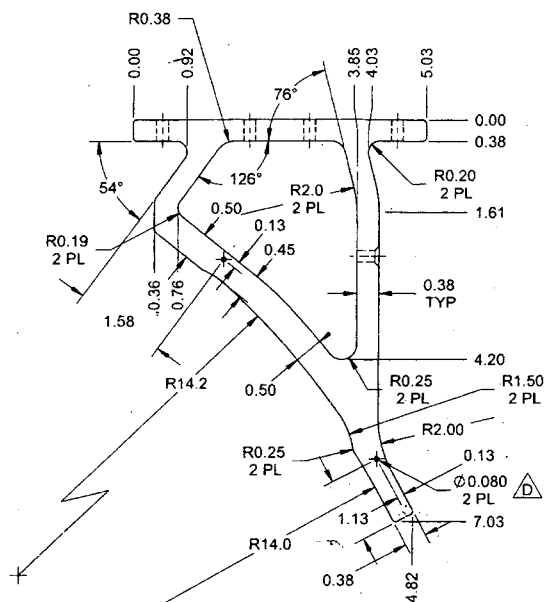
D4093-1 BRACKET

410 108292

D	ADD Ø0.080 HOLES (ZN B5-2, B5-4)	RF	12.09.18
C	REDRAWN D4093-1/1-3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1/1-3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.09.18		

DART AEROSPACE USA, INC.	
KENT, WA	
DRAWING NO.	REV. D
D4093	SHEET 1 OF 5
TITLE	SCALE
BRACKET	NTS

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D4093-1 BRACKET

RELEASED
2012-10-31
MM

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.09.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DART AEROSPACE LTD		Work Order:	108292
Description: Bracket		Part Number:	124093-1
Inspection Dwg: 124093	Rev: 12	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0,201	+ 0,005 - 0,001	0,204	✓		MIP-04	12mm
0,50	+ 0,030 - 0,010	0,493	✓	
1,500	+ 0,010 - 0,010	1,501	✓	
2,530	+ 0,010 - 0,010	2,525	✓	
1,500	+ 0,010 - 0,010	1,500	✓	
2,39	+ 0,030 - 0,010	2,380	✓	
Ø 0,370 x 100	+ 0,010 - 0,004	0,361	✓	
Ø 0,080	+ 0,004 - 0,001	0,089	✓	
1,58	+ 0,030 - 0,010	1,100	✓	
0,13	+ 0,030 - 0,010	0,112	✓	
1,130	+ 0,030 - 0,010	1,112	✓	
0,13	+ 0,030 - 0,010	0,136	✓	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 13/10/30	Date: 13/10/01	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15